

Date: Wednesday, 22/10/2008 11:47:20 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 42805	
Estimate Number : 10534	
P.O. Number :	Part Number : D2574
This Issue : 22/10/2008 S.O. No. :	Drawing Number : D2574 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision :
Previous Run : 35918	Material :
Written By :	Due Date : 06/01/2009 Qty: 12 Um: Each
Checked & Approved By : <u>JUD 08.10.22</u>	
Comment : Est Rev: I As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2574
 Ensure that grain is along 5.00" length
 Batch No: B34874

ml 08/10/31

(12)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 42805 Double check by: JTP

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

ml/J.F. 08/11/03

(12)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2573 & D2574

J.F. 08/11/03

(12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/11/03

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 22/10/2008 11:47:20 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 42805

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

2C 08/11/03 (12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/11/04 (12)

7.0

POWDER COATING

POWDER COATING



M102316



(12x)

Comment: POWDER COATING



Powder Coat **SANDTEX GREEN**
(Ref: 4.3.5.1) as per QSI 005 4.3

m-l 08/11/04

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

48

08-11-04

(x12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

sty31

08/11/05 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/06

Job Completion



MLF 08-11-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 42805
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	7.999	8.000		
F	0.490	0.510		.499	.502	.503	.502		
G	0.257	0.262		.260	.259	.258	.258		
H	0.375	0.380		.379	.377	.377	.377		
I	0.490	0.510		.500	.500	.502	.503		
J	1.174	1.184		1.179	1.179	1.177	1.177		
K	0.558	0.578		.570	.570	.569	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.369	1.369	1.370	1.370		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	4.119	4.129		4.122	4.122	4.123	4.123		
P	0.115	0.135		.125	.126	.125	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.251	.258	.258		
S	0.115	0.135		.123	.125	.125	.123		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.226	3.227	3.230	3.230		
V	0.230	0.250		.236	.237	.240	.242		
W	0.115	0.135		.133	.135	.135	.133		
X	0.307	0.312		.310	.311	.311	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.367	.367	.366		
AA	0.470	0.530		.500	.500	R.500	R.500		
AB	0.615	0.635		.626	.629	.630	.630		
AC	0.053	0.073		.063	.063	R.063	R.063		
AD	0.240	0.260		.244	.248	.251	.247		
AE	1.500	1.520		1.518	1.513	1.512	1.512		
AF	0.115	0.135		.135	.135	.125	.125		
AG	0.240	0.280		.270	.266	.260	.260		
AH	0.240	0.260		.246	.247	.250	.251		
AI	2.000	2.020		2.002	2.003	2.002	2.002		
AJ	0.023	0.043		.033	R.033	R.033	R.033		
Accept/Reject									

Measured by:	mf / J.F.
Date:	08/10/21 / 08/11/22

Audited by:	KJ
Date:	08/11/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 42805	
Description: Saddle, Aft Inboard		Part Number: D2574	
Inspection Dwg: D2574 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	17	18		
A	0.438	0.443		0.440"	0.440"	0.440"	0.440"		
B	1.745	1.755		1.750"	1.750"	1.750"	1.750"		
C	3.495	3.505		3.500"	3.500"	3.500"	3.500"		
D	1.745	1.755		1.750"	1.750"	1.750"	1.750"		
E	7.990	8.010		8.000"	8.000"	8.000"	8.000"		
F	0.490	0.510		.502"	.503"	.502"	.502"		
G	0.257	0.262		0.258"	0.258"	0.258"	0.258"		
H	0.375	0.380		0.377"	0.377"	0.377"	0.377"		
I	0.490	0.510		.504"	.504"	.507"	.505"		
J	1.174	1.184		1.177"	1.177"	1.177"	1.177"		
K	0.558	0.578		.570"	.574"	.575"	.571"		
L	1.174	1.184		1.179"	1.179"	1.179"	1.179"		
M	1.365	1.375		1.370"	1.370"	1.370"	1.370"		
N	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
O	4.119	4.129		4.123"	4.123"	4.123"	4.123"		
P	0.115	0.135		.126"	.126"	.125"	.125"		
Q	0.115	0.135		.135"	.135"	.135"	.135"		
R	0.240	0.260		.253"	.252"	.252"	.250"		
S	0.115	0.135		.125"	.124"	.125"	.125"		
T	0.178	0.198		R.188"	R.188"	R.188"	R.188"		
U	3.210	3.250		3.230"	3.230"	3.230"	3.230"		
V	0.230	0.250		.241"	.241"	.241"	.241"		
W	0.115	0.135		.130"	.129"	.130"	.130"		
X	0.307	0.312		.312"	.310"	.310"	.310"		
Y	0.760	0.765		.763"	.760"	.760"	.760"		
Z	0.352	0.372		.367"	.366"	.366"	.366"		
AA	0.470	0.530		R.500"	R.500"	R.500"	R.500"		
AB	0.615	0.635		.630"	.628"	.630"	.629"		
AC	0.053	0.073		R.063"	R.063"	R.063"	R.063"		
AD	0.240	0.260		.250"	.250"	.250"	.250"		
AE	1.500	1.520		1.513"	1.512"	1.512"	1.511"		
AF	0.115	0.135		.123"	.125"	.125"	.125"		
AG	0.240	0.280		.256"	.260"	.260"	.260"		
AH	0.240	0.260		.250"	.250"	.249"	.250"		
AI	2.000	2.020		2.003"	2.002"	2.002"	2.001"		
AJ	0.023	0.043		R.033"	R.033"	R.033"	R.033"		
Accept/Reject									

Measured by:	J.F.
Date:	08/11/03

Audited by:	RF
Date:	08/11/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 42805
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	#9	#10	#11	#12		
A	0.438	0.443		0.440"	0.440"	0.440"	0.440"		
B	1.745	1.755		1.750"	1.750"	1.750"	1.750"		
C	3.495	3.505		3.500"	3.500"	3.500"	3.500"		
D	1.745	1.755		1.750"	1.750"	1.750"	1.750"		
E	7.990	8.010		8.000"	8.000"	8.000"	8.000"		
F	0.490	0.510		0.502"	0.502"	0.504"	0.502"		
G	0.257	0.262		0.258"	0.258"	0.258"	0.258"		
H	0.375	0.380		0.377"	0.377"	0.377"	0.377"		
I	0.490	0.510		0.505"	0.506"	0.504"	0.503"		
J	1.174	1.184		1.178"	1.178"	1.178"	1.178"		
K	0.558	0.578		0.573"	0.572"	0.571"	0.570"		
L	1.174	1.184		1.180"	1.180"	1.180"	1.180"		
M	1.365	1.375		1.370"	1.370"	1.370"	1.370"		
N	2.495	2.505		2.501"	2.501"	2.501"	2.501"		
O	4.119	4.129		4.124"	4.124"	4.124"	4.124"		
P	0.115	0.135		0.125"	0.125"	0.125"	0.125"		
Q	0.115	0.135		0.135"	0.135"	0.135"	0.135"		
R	0.240	0.260		0.252"	0.252"	0.252"	0.250"		
S	0.115	0.135		0.125"	0.124"	0.123"	0.129"		
T	0.178	0.198		R.188"	R.188"	R.188"	R.188"		
U	3.210	3.250		3.229"	3.229"	3.229"	3.229"		
V	0.230	0.250		0.241"	0.240"	0.240"	0.242"		
W	0.115	0.135		0.130"	0.130"	0.130"	0.131"		
X	0.307	0.312		0.311"	0.311"	0.311"	0.311"		
Y	0.760	0.765		0.760"	0.760"	0.760"	0.760"		
Z	0.352	0.372		0.366"	0.366"	0.366"	0.366"		
AA	0.470	0.530		R.500"	R.500"	R.500"	R.500"		
AB	0.615	0.635		0.630"	0.629"	0.629"	0.629"		
AC	0.053	0.073		R.063"	R.063"	R.063"	R.063"		
AD	0.240	0.260		0.250"	0.249"	0.249"	0.250"		
AE	1.500	1.520	1	1.512"	1.512"	1.512"	1.512"		
AF	0.115	0.135		0.125"	0.125"	0.125"	0.125"		
AG	0.240	0.280		0.265"	0.265"	0.265"	0.265"		
AH	0.240	0.260		0.250"	0.250"	0.249"	0.252"		
AI	2.000	2.020		2.002"	2.002"	2.002"	2.002"		
AJ	0.023	0.043		R.033"	R.033"	R.033"	R.033"		
Accept/Reject									

Measured by: J.F.	Audited by: RF
Date: 08/11/02	Date: 08/11/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06

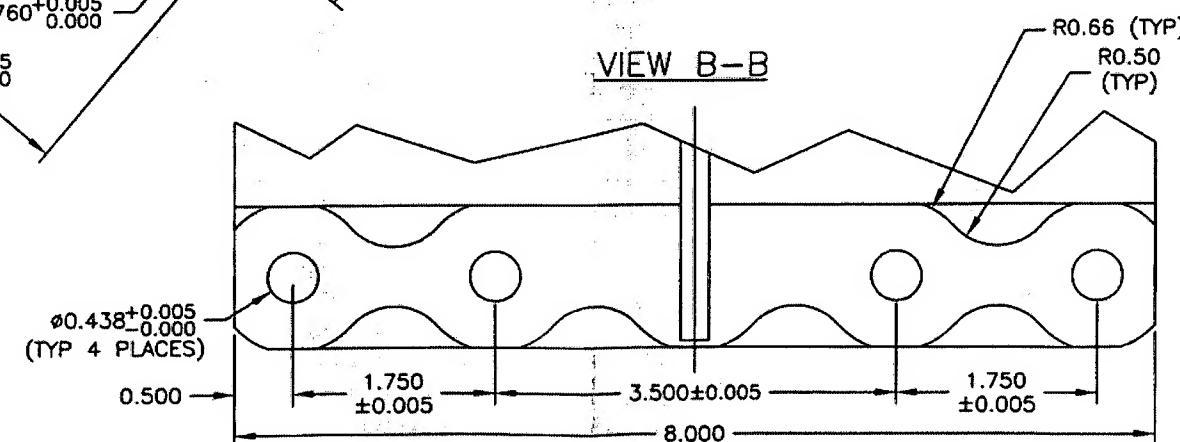
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

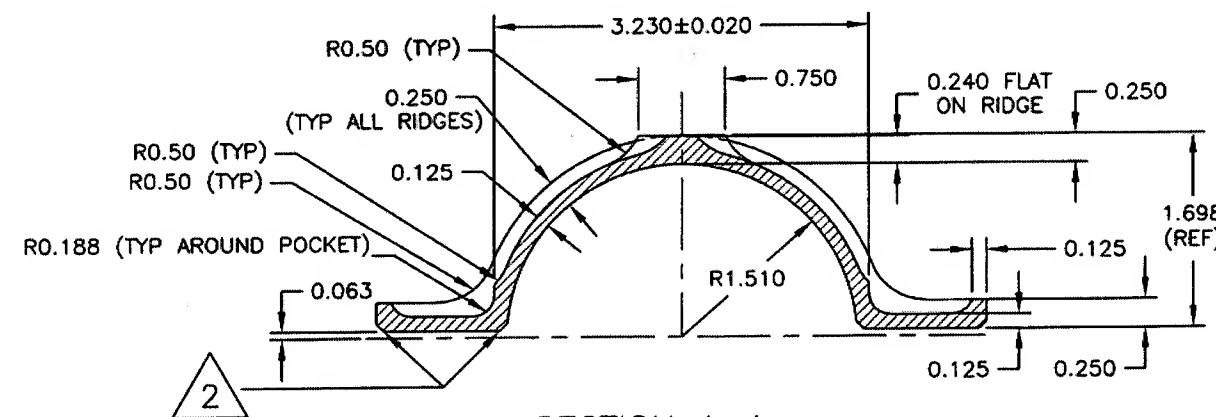
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)

E

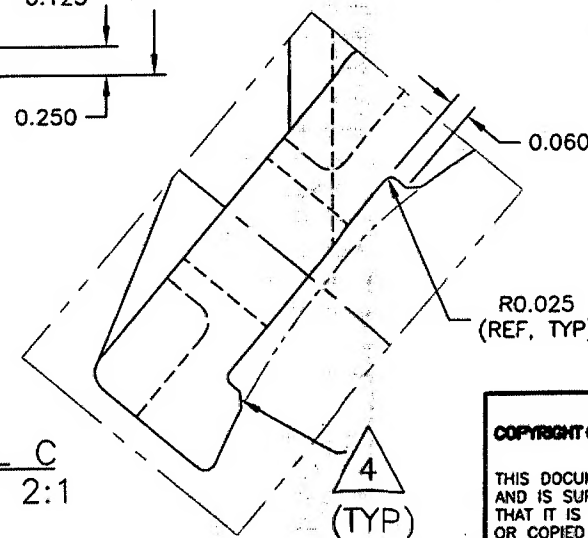
VIEW B-B



SECTION A-A



DETAIL C SCALE 2:1



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E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	05.07.13	TITLE
		INNER AFT SADDLE
		DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
		DRAWING NO. D2574
		REV. E
		SHEET 1 OF 1

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WITHOUT NOTICE
WORK ORDER
NO. 42805

